

JUL 20 2018



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

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D066-1001-011
Job Sheet 180960



Part No: D066-1001-011

Job Qty: 1 ea

Part Name: R66 Bearpaws With Wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 13-10-30 JLM VERIFIED BY:DD IPP REV:B 13.12.03 AS PER IIN
REV.B DD VERF:JLM IPP REV:C 15.04.08 AS PER CHG003 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs Hrs	Workcenter/Supplier	Lead Time	Sign off
90	Start up Operation	1 Ea		8/3/18	0.00 0.00	Start Up Stores/Pkg-1		NOV 23 2018
110	Packaging	1 pcs		8/3/18	0.00 0.00	Packaging1-1		NOV 23 2018
120	QC	1 pcs		8/3/18	0.00 0.00	QC4		NOV 26 2018
130	Packaging	1 pcs		8/3/18	0.00 0.00	Packaging3-1		NOV 26 2018
135	DC	1 pcs		8/3/18	0.00 0.00	DC		NOV 26 2018
140	QC21-FG	1 Ea		8/3/18	0.00 0.00	QC21		NOV 26 2018

Part Op 130 - Identify and pack for shipping as per PPP D066-1001-011 Location: _____ PPP Rev: 21
Descriptions: 135 - Photocopy bluefile & type labels per PPPD066-1001-011 CHG 003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-12A	Bolt	4 Ea (4 ea)	90-Start up Operation	FM136199
AN4-15A	Bolt	4 Ea (4 ea)	90-Start up Operation	5107130
AN4-16A	Bolt	4 Ea (4 ea)	90-Start up Operation	5121432
D3456-1	Washer	4 Ea (4 ea)	90-Start up Operation	5071335
D3556-1	R44 Bearpaw Clamp	4 Ea (4 ea)	90-Start up Operation	5084533
D3601-1	Radius Block	8 Ea (8 ea)	90-Start up Operation	5107136 FB2769X2
D4930-1	Bearpaw	2 Ea (2 ea)	90-Start up Operation	5032038
D4952-041	Wearplate Assembly	4 Ea (4 ea)	90-Start up Operation	F158902 5053213
D4953-1	Cushion	4 Ea (4 ea)	90-Start up Operation	F153229
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation	5109136
NAS1149D0463J	Washer	8 Ea (8 ea)	90-Start up Operation	5092790

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-12A	4	153	0
	AN4-15A	4	453	0
	AN4-16A	4	269	0
	D3456-1	4	288	0
	D3556-1	4	64	0
	D3601-1	8	124	0
	D4930-1	2	6	0
	D4952-041	4	15	0
	D4953-1	4	280	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power ☐ Folio/F ☐ Grain ☐ Weld ☐ Wron ☐ Out o ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		
OTHER : _____				

Container No: S130931
 Part: D066 - 1001 - 011
 Job No: 180960
 Serial No/Batch: S130931
 Revision:
 Inspector:
 Exp Date:
 Instructions: TC STC SH13 - 43 - Issued, FAA STC SR03370NY 14/03/13, EASA

By _____
 Supervisor
 Coordinator
 al
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 Hawthorn, VIC 3122
 CANADA
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 www.dartaerospace.com

MS21042L4
NAS1149D0463J

12
8

3,594
11,622

0
0

Part Specifications

Specifications could not be found.

Plex 7/18/18 10:54 AM Dart.lajeunesse.marie



QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due				FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
				OTHER :							

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1001-011	8.3 lb	0.0 in	0.0 in-lb	123.89 in	1028 in-lb
<i>Bearpaw Installation (Small)</i>	3.74 kg	0.0 m	0.0 m-kg	3.14 m	11.7 m-kg
D066-1001-013	9.8 lb	0.0 in	0.0 in-lb	124.98 in	1225 in-lb
<i>Bearpaw Installation (Large)</i>	4.41 kg	0.0 m	0.0 m-kg	3.17 m	14.0 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D066-1001-011	BEARPAW INSTALLATION (SMALL)
	X	D066-1001-013	BEARPAW INSTALLATION (LARGE)
4	4	D3456-1	Washer
4	4	D3556-1	Clamp
8	8	D3601-1	Radius Block
2		D4930-1	Bearpaw
	2	D4930-3	Bearpaw
4	4	D4952-041	Wearplate
4	4	D4953-1	Cushion
4	4	AN4-12A	Bolt
4	4	AN4-15A	Bolt
4	4	AN4-16A	Bolt
8	8	NAS1149D0463J	Washer
12	12	MS21042L4	Nut (or MS21042-4)

REFERENCE ONLY

NOV 26 2018

REFERENCE ONLY

RECEIVED ON 7

RECEIVED ON 1

NOV 2 8 2018

RECEIVED ON 1